

5/24

DART AEROSPACE LTD	Work Order:	23246
Description: Outer Aft Saddle	Part Number:	D5955
Drawing: D5955 Rev. A	Qty:	8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required</i>	<i>JA</i>	05.05.11	8
2	STORES	Issue material from stock: D6101-013 (7075-T7351) Cut Size 2.50" x 10.10" X 8.25" (Grain along 10.10") <i>821500</i> • Batch: <i>B23537</i>	<i>ml</i>	05/07/06	8
3	HAAS	Setup W/O No. _____ Setup Inspection last completed _____ by _____	<i>N/A</i>		
4	HAAS	Machine as per folio D5955 Ensure Batch Number is entered	<i>CE</i>	05.07.08	8
5	HAAS	Deburr and Tumble	<i>CE</i>	05.07.08	8
6	QC	Inspect Level 1 Fill Out Inspection Sheet	<i>CE</i>	05.07.08	8
7	QC	Inspect Level 8 Audit Inspection Sheet	<i>SD</i>	05.07.08	8
8	METAL	Acid etch and alodine as per QSI 005 4.1	<i>FF</i>	05.07.11	8
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	<i>ml</i>	05.07.11	8
10	QC	Inspect Level 3	<i>CL</i>	05/07/11	8
11	STORES	Pack in foam, identify and stock	<i>CL</i>	05/07/11	8
12	EXPEDITING	Close Work Order <i>226.41</i> Cost / Part <i>226.41</i>	<i>JA</i>	05/07/11	8

Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06 *JA*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-07-08	4	- 1 part scrap, power failure caused spindle head to drop 0.125"	<i>[Signature]</i>	Scrap: replace	<i>[Signature]</i> 05-07-11	<i>[Signature]</i> 05-07-11	<i>[Signature]</i>	<i>[Signature]</i> 05-07-11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/07/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	23246
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D5955 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	5.245	5.255		5.248	5.250	5.249	5.249		
D	6.995	7.005		6.998	6.999	6.998	7.000		
E	5.745	5.755		5.747	5.750	5.750	5.750		
F	4.745	4.755		4.748	4.750	4.750	4.750		
G	0.313	0.318	DT8686						
H	1.522	1.532		1.525	1.525	1.524	1.526		
I	3.048	3.058		3.053	3.053	3.053	3.052		
J	4.575	4.585		4.582	4.582	4.582	4.582		
K	0.313	0.318	DT8686						
L	0.240	0.260		0.252	0.251	0.252	0.252		
M	0.490	0.510		0.503	0.498	0.495	0.501		
N	0.240	0.260		0.251	0.250	0.251	0.251		
O	7.990	8.010		8.000	8.002	8.002	8.002		
P	0.240	0.260		0.255	0.253	0.253	0.248		
Q	0.307	0.312		0.311	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.761	0.761	0.761		
S	0.490	0.510		0.501	0.509	0.508	0.508		
T	1.625	1.645		1.640	1.640	1.635	1.638		
U	2.000	2.020		2.005	2.005	2.002	2.001		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EC
Date:	05-07-08

Audited by:	SL
Date:	05-07-08

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	

RELEASED
03.06.18

DART AEROSPACE LTD		Work Order:	23246
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D5955 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.751	1.749	1.750		
C	5.245	5.255		5.250	5.250	5.249	5.250		
D	6.995	7.005		6.999	7.000	7.001	7.000		
E	5.745	5.755		5.750	5.750	5.751	5.750		
F	4.745	4.755		4.750	4.749	4.750	4.749		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.526	1.527	1.528	1.528		
I	3.048	3.058		3.052	3.052	3.052	3.052		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		0.252	0.251	0.251	0.250		
M	0.490	0.510		0.501	0.497	0.498	0.500		
N	0.240	0.260		0.252	0.251	0.251	0.251		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	0.240	0.260		0.247	0.249	0.248	0.248		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.761	0.762	0.761	0.761		
S	0.490	0.510		0.508	0.492	0.508	0.508		
T	1.625	1.645		1.638	1.638	1.638	1.638		
U	2.000	2.020		2.002	2.004	2.004	2.002		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	PC
Date:	05-07-08

Audited by:	SN
Date:	05-07-08

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	

RELEASED
03.06.18

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 09, 2005
02:16 pm

Work Order No : 0023246
Project Name : D5955
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D5955

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Description : Saddle
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 05-09-05
Est Finish Date : 06-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00